

8" JOINTER

Model 60A

Instruction Manual & Parts List

M-0460258



POWERMATIC
WMH TOOL GROUP

(800) 274-6848
www.wmhtoolgroup.com

This manual has been prepared for the owner and operators of a Powermatic Model 60A, 8" Jointer. Its purpose, aside from machine operation, is to promote safety through the use of accepted correct operating and maintenance procedures. Completely read the safety and maintenance instructions before operating or servicing the machine. To obtain maximum life and efficiency from your jointer and to aid in using the machine safely, read this manual thoroughly and follow all instructions carefully.

Warranty & Service

The WMH Tool Group warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Repair Stations located throughout the United States can give you quick service.

In most cases, any one of these WMH Tool Group Repair Stations can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET, Powermatic, Performax, or Wilton tools.

For the name of an Authorized Repair Station in your area, please call 1-800-274-6848.

More Information

Remember, the WMH Tool Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local WMH Tool Group distributor.

WMH Tool Group Warranty

The WMH Tool Group makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follow: 1 YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE. This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, repair or alterations outside our facilities, or to a lack of maintenance.

THE WMH TOOL GROUP LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD SPECIFIED ABOVE, FROM THE DATE THE PRODUCT WAS PURCHASED AT RETAIL. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. THE WMH TOOL GROUP SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an Authorized Repair Station designated by our office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product, or refund the purchase price if we cannot readily and quickly provide a repair or replacement, if you are willing to accept a refund. We will return repaired product or replacement at WMH's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of WMH's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

The WMH Tool Group sells through distributors only. Members of the WMH Tool Group reserve the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

TABLE OF CONTENTS

Safety Rules	4-5
Decal Instruction	6
Specifications	7
Features	7
Receiving the Jointer	8
Installation & Assembly	8
Electrical Installation	9
Mounting Drive Belt	9
Aligning Pulleys	9
Mounting Pulley Guard	9
Mounting Dust Adaptor	9
Adjustments	10
Removing Cutterhead Guard	10
Leveling Tables	10
Adjusting Depth of Cut	11
Spring Cutting	12
Squaring the Fence	12
Fence Movement & Tilting	12
Installing New Knives	13
Sharpening the Knives	14
Cutterhead Removal	15
Bearing Replacement	16
Table Removal	16
Basic Jointer Operation	17
Surfacing (Planing)	17
Edging (Jointing)	18
Beveling	18
Skewing (Shear cutting)	19
Rabbeting	19
Push Blocks	20
Parts Lists & Exploded Views:	
Cutterhead Guard Assembly	21
Base & Table Assembly	22-24
Cutterhead Assembly	25
Fence Assembly	26-27
Stand Assembly	28-29
Knife-Setting Gauge (Optional Accessory)	30
Electrical:	
1-1/2 HP, Single Phase, 230 Volt	31
NHD: Single Phase/230 Volt	32
NHD: Three Phase/230/460 Volt	33
Magnetic Starters	34
Optional Accessories	34
Preventive Maintenance Check List	35

Safety Rules

As with all machines, there is a certain amount of hazard involved with the use of this jointer. Use the machine with the respect and caution demanded where safety precautions are concerned. When normal safety precautions are overlooked or ignored, personal injury to the operator can result.

Read the manual. Read, understand, and follow the safety instructions found in this manual. Know the limitations and hazards in using the model 60 - 8" Jointer. Decals are placed on each machine as reminders of good safety practice.

Installation. If mounting machine to the floor, use high quality anchor bolts through the mounting holes on the base. If using a mobile base, be sure to lock the wheels.

Location. Use extra care in the location of the jointer in the shop. Place the machine so that potential kickback area is not in line with aisles, doorways, wash stations, or other work areas.

Electrical grounding. Make certain that the machine frame is electrically grounded and that a ground lead is included in the incoming electrical service. If a cord and plug are used, make certain the grounding lug connects to a suitable ground. Follow the grounding procedure indicated in the National Electric Code.

Eye safety. Always wear approved safety goggles, glasses, or a face shield when operating this machine. There are no exceptions to this rule.

Personal protection. Before operating the machine, remove tie, rings, watch and other jewelry and roll up sleeves above the elbows. Remove all loose clothing and confine long hair. Protective type footwear should be used. Where the noise exceeds the level of exposure allowed in Section 1910.95 of the OSHA Regulations, use hearing protective devices. Do not wear gloves.

Guards. Be sure machine guards are in place and in good working order. Use them at all times on operations where they can be used. If a guard must be removed for any operation, make sure it is replaced immediately following completion of that operation.

Work area. Keep the floor around the machine clean and free of scrap material, saw dust, oil and other liquids to minimize the danger of tripping or slipping. Be sure the table is free of all scrap, foreign material and tools before starting to cut. Make certain the work area is well lighted and that a proper exhaust system is used to minimize dust. Powermatic recommends the use of anti-skid floor strips on the floor area where the operator normally stands and that each machine's work area be marked off. Provide adequate work space around the machine.

Disconnect machine before performing any service or maintenance. A machine under repair should be RED TAGGED to show it should not be used until the maintenance is complete.

Housekeeping. Before turning on machine, remove all extra equipment such as keys, wrenches, scrap, stock, and cleaning rags away from the machine.

Power on. On machines equipped with a manual starter make sure the starter is in "OFF" position before connecting power to machine.

Never surface stock less than 12 inches long, or 3 inches wide, or 3 inches thick without a hold-down push block.

Three inch rule. When working a piece of wood on the jointer, follow the 3 inch radius rule. The hands must never be closer than 3 inches to the cutterhead. See Figure i.

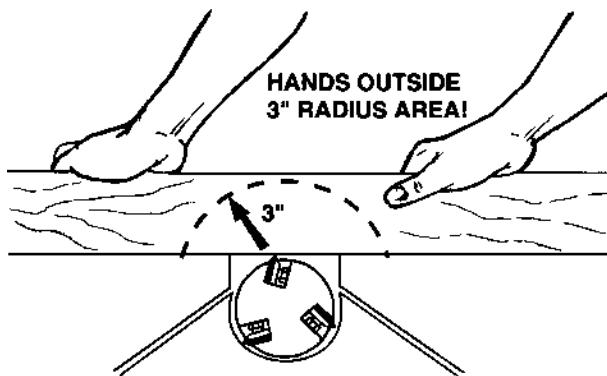


FIGURE i

Avoid tip-in. Never apply pressure to stock directly over the cutterhead. This may result in the stock tipping into the cutterhead along with the operator's fingers. Follow the 3 inch rule. Position hands away from extreme ends of stock, and push through with a smooth, even motion.

Avoid Kickback. "Pull-out" and the danger of kicked back stock can occur when the work piece has knots, holes, or foreign materials such as nails. It can also occur when the stock is fed against the grain on the jointer. The grain must run in the same direction you are cutting. Before attempting to joint, or plane, each work piece must be carefully examined for stock condition and grain orientation.

NOTE: At certain times it may be necessary to plane against the grain when working with a swirl grain wood or burls. With this type work the operator must use a lesser depth of cut and a slow rate of feed.

Hand safety. It is good practice to move the hands in an alternate motion from back to front as the work continues through the cut. Never pass the hands directly over the cutter knife. As one hand approaches the knives remove it from the stock in an arc motion and place it back on the stock in a position beyond the cutter knife (Figure ii).

NOTE: At all times hold the stock firmly.

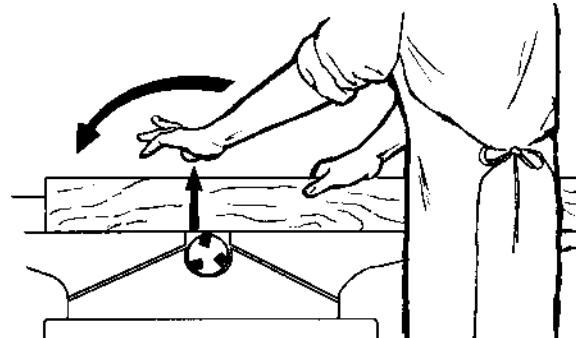


FIGURE ii

Misuse. Do not use this jointer for other than its intended use. If used for other purposes, Powermatic disclaims any real or implied warranty and holds itself harmless for any injury or damage which may result from that use. Do not equip or use this jointer with a motor larger than 2 Horsepower at 3600 R.P.M. or operate the cutterhead in excess of 7,000 R.P.M. Use of a larger horsepower motor or higher cutterhead speed voids the warranty and Powermatic holds itself harmless for any injury which may result.

If you are not thoroughly familiar with the operation of jointers, obtain advice from your supervisor, instructor or other qualified person.

Drugs, alcohol, medication. Do not operate tool while under the influence of drugs, alcohol, or any medication.

Health hazards. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- * Lead from lead-based paint.
- * Crystalline silica from bricks and cement and other masonry products.
- * Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter out microscopic particles.

Familiarize yourself with the following safety notices used in this manual:



CAUTION: (This means that if precautions are not heeded, it may result in minor or moderate injury and/or possible machine damage)



WARNING: (This means that if precautions are not heeded, it could result in serious injury or possibly even death).

⚠ SAFETY DECALS

Familiarize yourself with the location of these decals on your jointer.

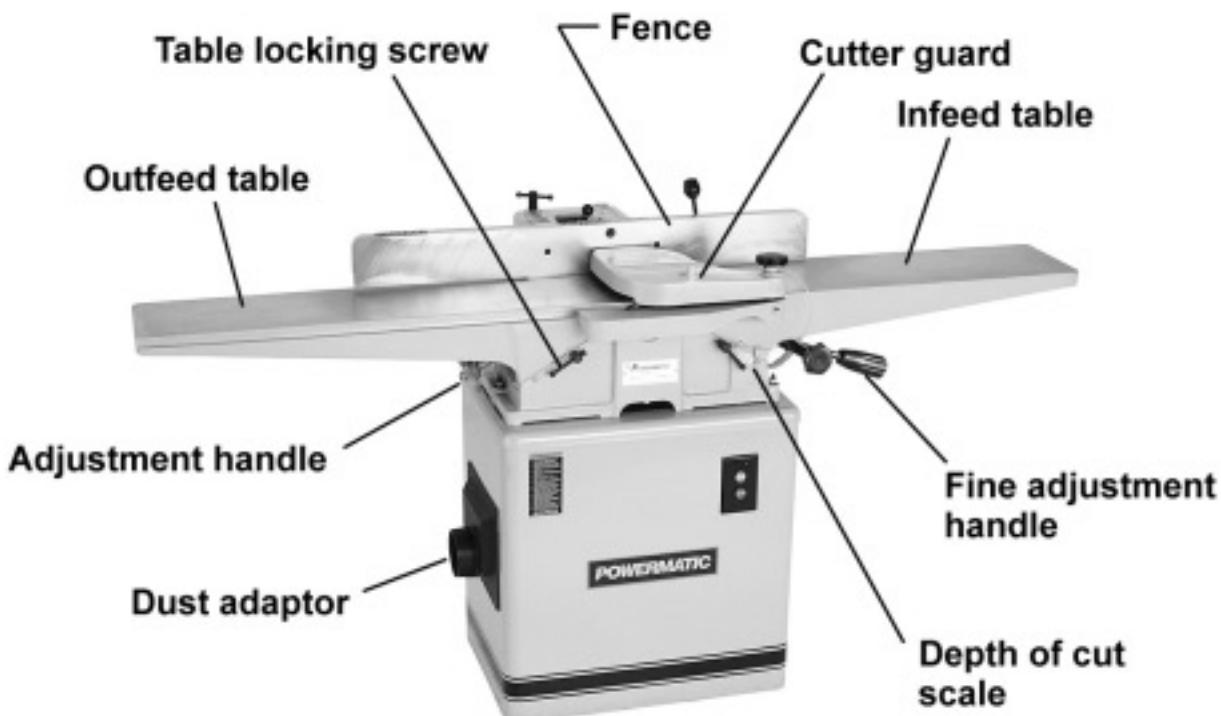


SPECIFICATIONS: Model 60A, 8" Jointer

Table	8-1/2" x 72"
Head cutting arc	3"
Knives (3) H.S. steel	1/8" x 11/16" x 8"
Speed of head (maximum)	7,000 rpm
Knife-cuts-per-minute	21,000
Maximum depth of cut	1/2"
Maximum rabbeting cut	1/2" x 8"
Fence size overall4" x 36"
Height, less stand	12-1/2"
Height, with stand	35-7/8"
Motor recommended	3/4 to 2 HP
Weight, domestic crated with stand & motor	584 lbs.

NOTE: The above specifications were current at the time this manual was published, but due to our policy of continuous improvement Powermatic reserves the right to change specifications without notice and without incurring obligations.

FEATURES of the Model 60A



RECEIVING THE JOINTER

Remove the jointer assembly and stand from their respective shipping crates and inspect for damage. Any damage should be reported to your distributor and shipping agent immediately. Before proceeding further, read your manual thoroughly to familiarize yourself with proper assembly, set-up, maintenance and safety procedures.

Crate 1 contents:

- 1 Stand with motor
- 1 Door

Crate 2 contents:

- 1 Table & fence assembly
- 1 Dust collector adaptor
- 1 Drive belt
- 1 Belt guard
- 1 Cutterhead guard
- 1 Hardware bag
- 1 Open-end wrench

The contents of the hardware bag are drawn full scale in Figure 1.

NOTE: Exposed metal parts such as the table and fence have been given a protective coating at the factory. This should be removed with a soft cloth and solvent (such as mineral spirits) once the machine has been assembled. Do not use an abrasive pad.

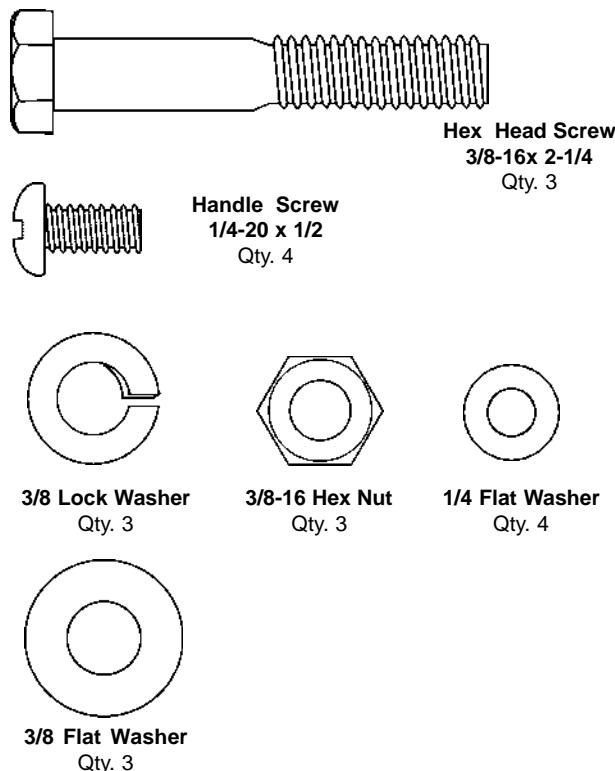


FIGURE 1

INSTALLATION & ASSEMBLY

Tools required

- 9/16", 1/2", and 5/8" wrenches
- Phillips screwdriver
- 5/32" hex wrench

Locate jointer on a level floor. If using a mobile base, be sure to lock the wheels before assembling, operating or adjusting the jointer.

1. With a hoist or an assistant, lift the table and fence assembly on to the stand, making sure it faces the right direction (the cutterhead pulley and motor pulley should line up).
2. Align the holes in the bottom of the jointer bed with the holes in the top of the stand, and secure with three 3/8-16 x 2-1/4 mounting screws, three 3/8 hex nuts, three 3/8 flat washers, and three 3/8 lock washers. Tighten with a 9/16" wrench. See Figure 2.

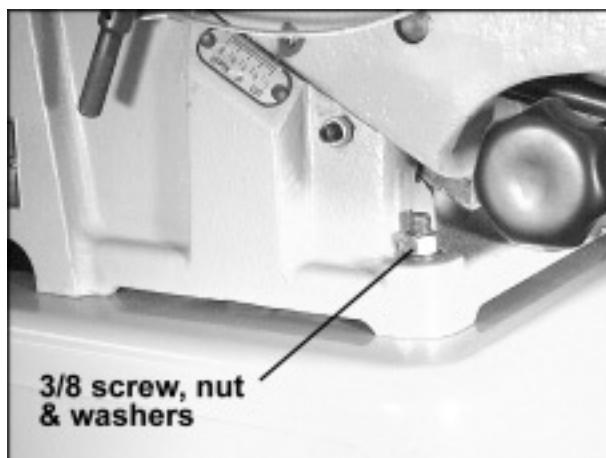


FIGURE 2

ELECTRICAL INSTALLATION

WARNING: If the machine does not come wired to run, the electrical and motor wiring must be done by a qualified electrician. The machine must be properly grounded to help avoid electrical shock and possible death.

MOUNTING DRIVE BELT

1. Place the belt over the cutterhead pulley and through the hole in the stand.
2. With a 9/16" wrench, loosen the nut on the adjusting screw (A) of the motor support plate (B) and lift the motor support up until the belt can be rolled onto the motor pulley. See Figure 3.
3. Push down on the motor support and retighten the nut on the adjusting screw (A) to create tension on the belt.
4. Using thumb and index finger, compress belt at center until it becomes taut. See Figure 4. At this point the distance between the in-sides of the belt should be one inch. Raise or lower the adjusting screw on the motor support as necessary until this proper tension is achieved.

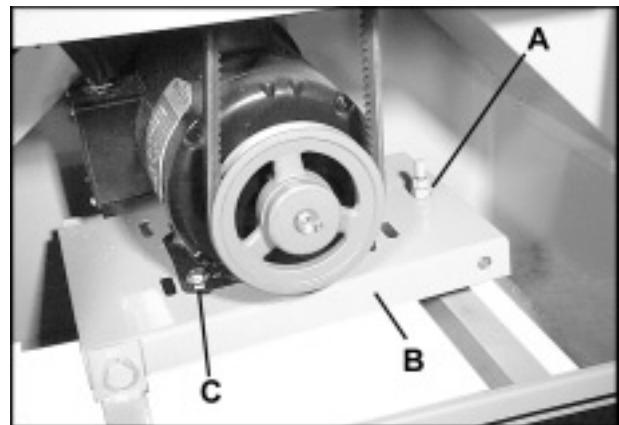


FIGURE 3

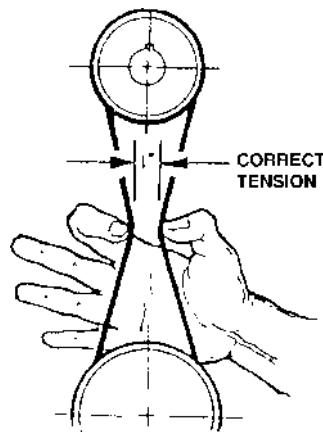


FIGURE 4

ALIGNING PULLEYS

Check that the motor and cutterhead pulleys are aligned. If adjustments are necessary, loosen the screws (C) in the motor support plate, as shown in Figure 3, and slide the motor back or forward as needed. Re-tighten screws when finished.

MOUNTING PULLEY GUARD

Place the pulley guard (A) as shown in Figure 5, and secure by screwing on the knob (B).

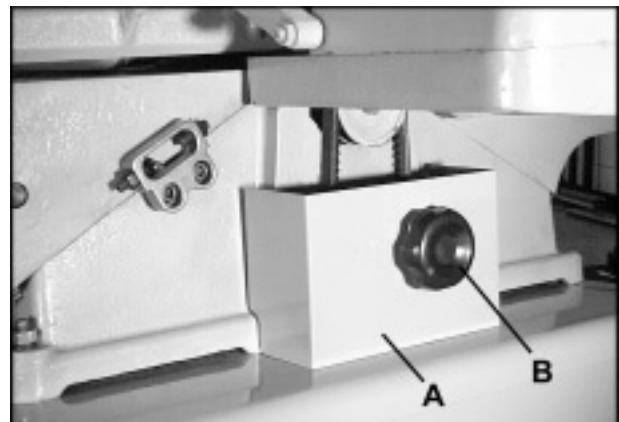


FIGURE 5

MOUNTING DUST ADAPTOR

Place the dust adaptor over the opening in the jointer stand, and secure with four 1/4-20 x 1/2 handle screws and four 1/4 flat washers. See Figure 6.



FIGURE 6

ADJUSTMENTS

Check all mounting screws and set screws to see that they are locked.

CAUTION: Disconnect machine from power source before making adjustments.

REMOVING CUTTERHEAD GUARD

Some adjustment procedures, as well as rabbeting operations, will require removal of the guard.

1. Loosen lock nut (A) on rabbeting ledge with a 1/2" wrench. Loosen set screw (B) with a 5/32" hex wrench. See Figure 7.

2. Vertically lift guard assembly out of the hole.

3. To re-install the guard properly, tension must be placed on the spring. Push the guard shaft down into the hole on the rabbeting ledge, and turn the top knob (C) clockwise until the desired tension is reached.

4. Continue holding the knob, and tighten the set screw (B). Tighten the lock nut (A) to prevent set screw from backing out.

5. With the fence moved back toward the rear edge of the table, test the guard tension by swinging the guard away from the fence and then releasing it. If tension is too strong or too weak, re-adjust as necessary.

NOTE: The guard must operate freely and must not drag on the rabbeting ledge or infeed table. If dragging occurs, replace the guard assembly.

LEVELING TABLES

Periodically check the parallelism of the infeed and outfeed tables by placing a steel straight edge (or carefully jointed wood) across both tables. Non-parallelism caused by loose gib may be corrected by the following procedure:

1. Loosen lock nuts on the gib screws (A), then loosen the gib screws, and the table lock handle (B). See Figure 8.

2. Remove lower gib screw (A*) and check screw hole to make sure that punch mark in the gib is aligned with the screw hole. If punch mark is not visible, or it does not line up with screw hole, use a screwdriver to lightly tap the gib back up into alignment.

3. Replace the lower gib screw (A*) but do not tighten.

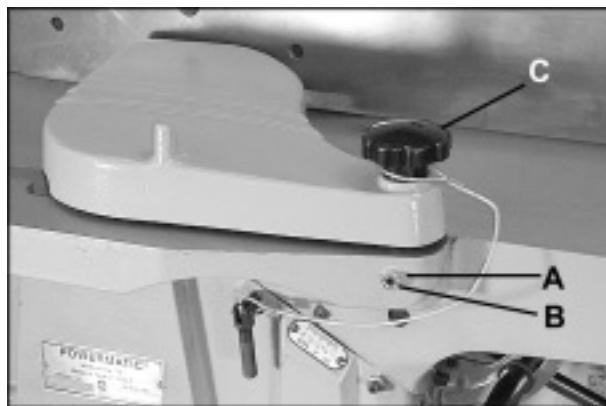


FIGURE 7

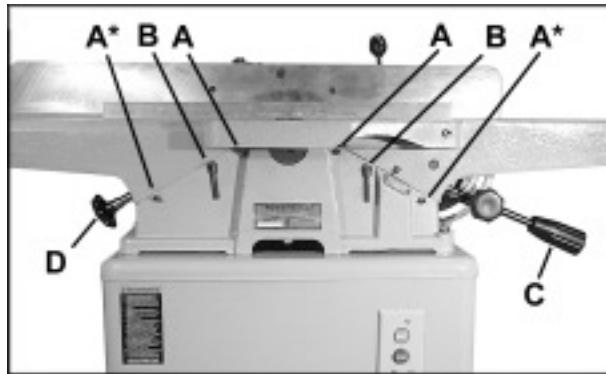


FIGURE 8

4. Carefully tighten the table lock screw (B) as shown in Figure 8. The table will begin to move toward the straightedge.

5. When aligned, reset the gib screws (A) until tight. If table does not align with straightedge, use the adjusting arm (C) for the infeed table, or handwheel (D) for the outfeed table, until the table is flush with the straightedge.

6. Tighten the gib screws (A) then back off approximately 1/4 turn or until the table moves freely, and reset lock nuts on the gib screws.

If table will not line up:

Remove gib screws and table locking handle and remove gib. Check gib to see that set screws do not go all the way through the gib or dimple the opposite side. If either of these conditions exist, replace with a new gib.

Also, check to be sure the ways are clean and free of pitch and sawdust. Lubricate gib and way with a good grade of non-hardening grease.

Replace the gib making certain that the punch mark lines up with locking screw holes. Replace gib screws. Repeat steps 3 thru 6.

ADJUSTING DEPTH OF CUT

Depth of cut is determined by the height of the infeed table relative to the cutterhead.

To adjust infeed table:

1. Loosen the lock screw (A), and the locking handle (B). See Figure 9.

2. Raise or lower the height adjustment handle (C) until the scale (D) reads approximately at the correct depth of cut.

3. Turn the locking handle (B) until it is snug, then fine-tune the adjustment with the height adjustment handle (C) by rotating it until the scale reads exact. (Clockwise raises the table, counterclockwise lowers the table.) The fine adjustment handle has 1/16" travel per rotation.

4. When set, retighten lock screw (A).

Periodically check the accuracy of the depth of cut scale (D) by raising the infeed table until it is flush with the peak of the cutterhead arc (using a straight edge across table and cutterhead). The scale should read zero depth. If it does not, readjust the pointer.

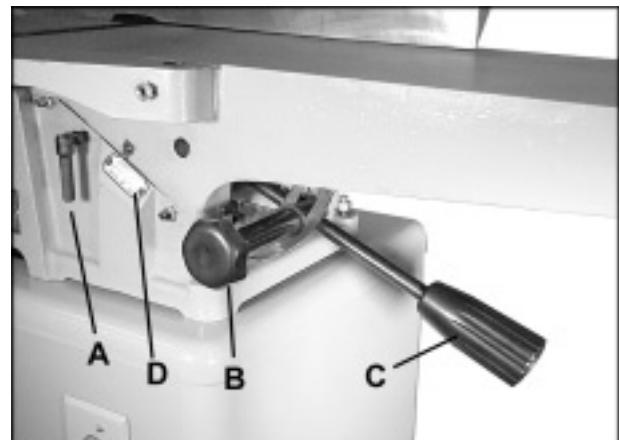


FIGURE 9

SPRING CUTTING

To spring cut, the outfeed table is lowered below the level of the cutterhead, as in Figure 10. Loosen both gib screws (A) on the outfeed table. Amount of end-drop is controlled with the table lock screw (B). Tighten handle to reduce amount of drop. A 1/32" drop usually creates the ideal concave for spring joints. Return the outfeed table to be in line with the cutterhead knives on completion of the cut.

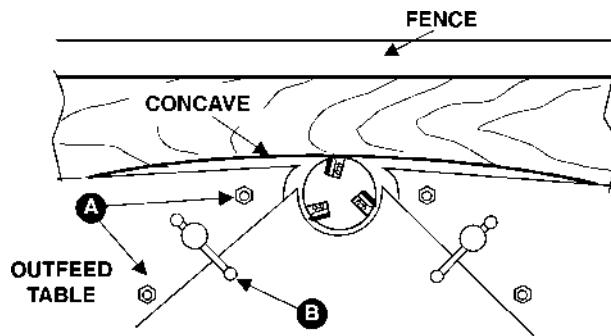


FIGURE 10

SQUARING THE FENCE

Before operating the jointer, it is important to check that the fence is perpendicular to the table.

1. Loosen the lock screw (A), as shown in Figure 11, and adjust the fence to the 90 degree position. (NOTE: There will be some play in the fence when it is unlocked. All play must be removed by tilting the fence toward or away from the table while locking the lock screw. Always remove the backlash by tilting the fence in the same direction while tightening.)

2. Place a 90 degree square on the outfeed table near the cutterhead, and up against the fence. If the fence does not come to 90 degrees, make the following correction.

3. Loosen lock nut (B) and insert a tool (such as a hex head wrench) into the hole in the tilt rod (C).

4. Turn tilt rod clockwise or counterclockwise until the fence lies flush against the square. Tighten lock nut (B).

5. Check your adjustment by loosening lock screw (A) and pulling up plunger (D), allowing fence to tilt out of 90 degrees. Then return it to 90 degree position.

6. Should the fence fail to return to 90 degrees and play is evident in the fence, remove the plunger mechanism (D) by loosening the jam nut (E) with a 5/8" wrench. Inspect the conical portion of the plunger assembly. If the tilt rod shows signs of wear or scarring, grind the conical portion of plunger, Figure 12, until it will fully engage in the annular groove in the tilt rod. Replace plunger assembly and tighten jam nut.

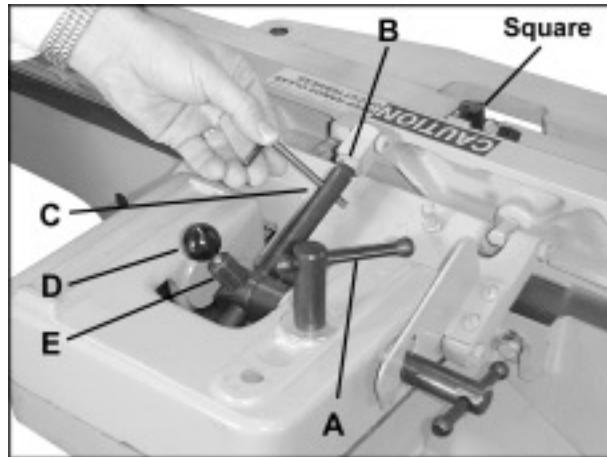


FIGURE 11

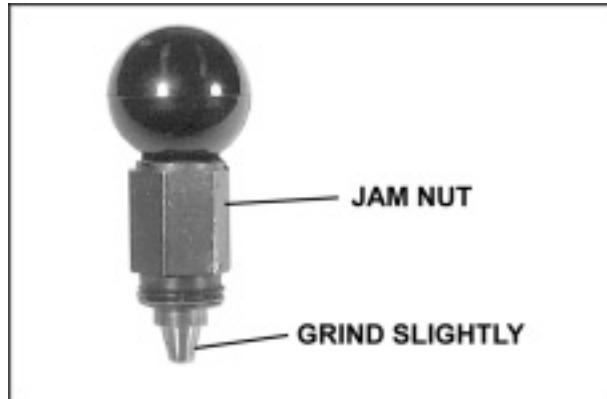


FIGURE 12

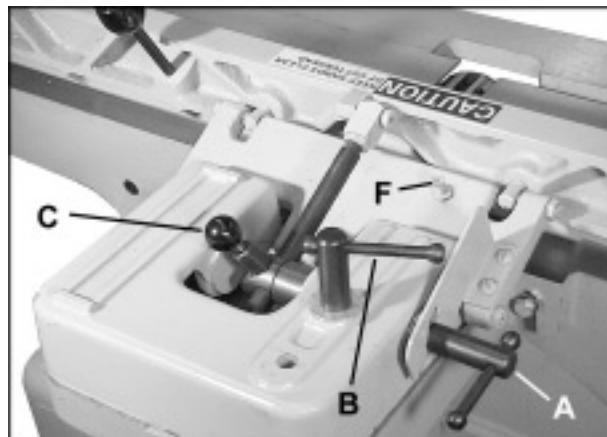


FIGURE 13

NOTE: Lift up slightly on the fence while moving it to prevent scratching the jointer table.

The fence may also be tilted forward or backward:

1. To tilt the fence forward in the cradle-cut position, loosen the fence lock screw (B). Pull up on the fence lock plunger (C) and tilt the fence forward.
2. Check the setting with a machinists protractor or adjustable square.
3. The two jam nuts (D & E) on the end of the tilt rod are factory pre-set to stop the forward tilt at 45 degrees. See Figure 14. The front nut (D) is used for adjusting and the rear nut (E) to lock the setting. When all adjustments have been made retighten the fence lock screw (B), Figure 13.
4. To tilt the fence backward, loosen the fence lock screw (B). Raise or lower the tilt stop screw (F). When the desired degree of cut is reached, retighten the fence lock screw (B).

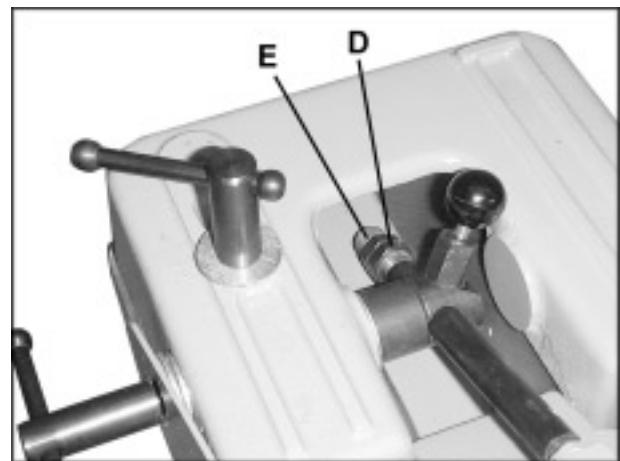


FIGURE 14

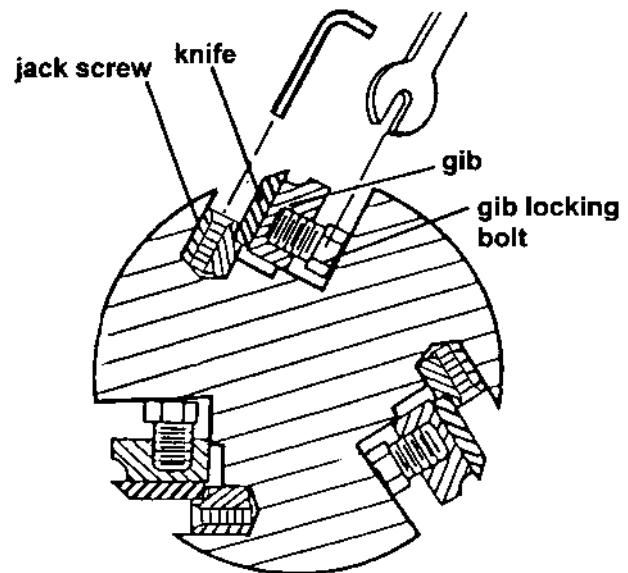


FIGURE 15

INSTALLING NEW KNIVES

When installing new knives remove only one knife at a time. Clean the knife slot and install the new knife. Adjust and lock new knife in cutterhead assembly before proceeding to next knife.

1. Disconnect jointer from power source.
2. Remove the old knives by loosening gib locking bolts and removing gib, knife, and jack screws, Figure 15.
3. With a hex head wrench, turn jack screws down one turn. Clean the jack screws, gib, knife slot, and knife thoroughly and replace jack screws.
4. Sandwich knife and gib together and drop into knife slot. Be certain that the back of the knife is resting on the seat of the jack screw plug.
5. To position the knife for rabbeting cuts, a 1/32 inch shop scale should be placed flat on the end of the cutterhead or the rabbet slot, whichever extends the farthest. Slide the knife out until it is flush with the end of the shop scale. Set the knife locking gib 1/32 inch in from the end of the knife. See Figure 16.

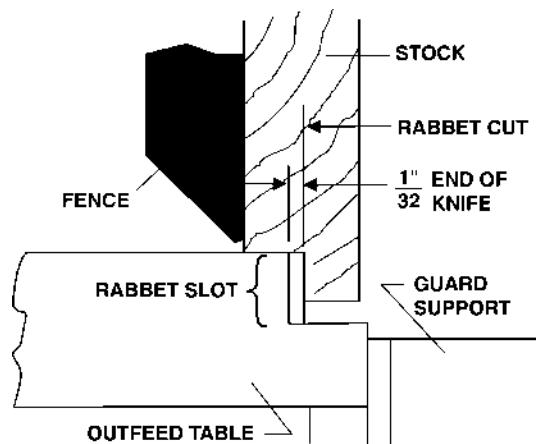


FIGURE 16

Setting the proper knife height:

WARNING: Set the knives no more than .015 inches above the body of the cutterhead to minimize the hazard of kickback and severe personal injury.

6. Snug the two outside gib locking screws.
7. If you have a Quick-Set Knife Gauge (available from POWERMATIC), place it on the outfeed table and "0" the indicator as shown in Figure 17.
8. Lift the knife gauge off the outfeed table to see how far below the bottom of the gauge the indicator travels. The indicator should read between .025 and .050 as shown in Figure 18.
9. If the indicator reads outside of this range, loosen the setscrew in the side of the gauge and adjust the indicator so that it will read within the range above. Zero the indicator as shown in Figure 17. Repeat this process until indicator reads within the .025 to .050 range. Always zero the indicator (as shown in Figure 17) before each use.
10. Now place it on the outfeed table to the *rear* of the cutterhead with the flat indicator point over the cutterhead. See Figure 19.
11. Insert a hex head wrench into the jack screw and rock the cutterhead back and forth. Watch the pointer on the knife gauge. The pointer will begin moving toward "0". When the pointer reaches "0", it is parallel with the outfeed table.
12. Move the gauge to the *front* of the cutterhead and repeat the above procedure.

This adjusting process puts the knife into the knife slot with the tip parallel and flush with the outfeed table. Once the correct knife height has been established, secure the gib locking screws. (Begin with the center screw to prevent buckling or uneven knives.)

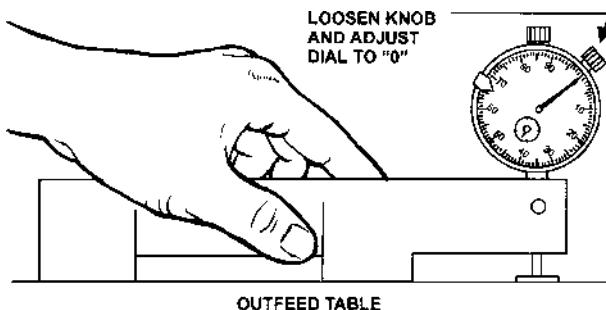


FIGURE 17

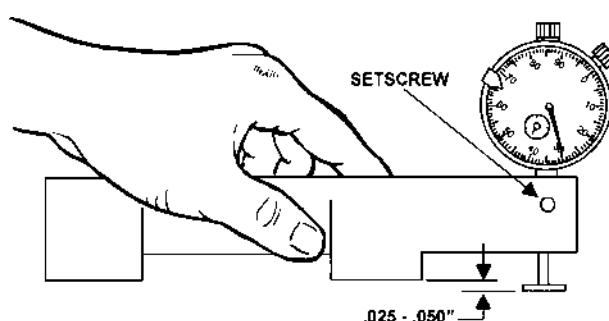


FIGURE 18

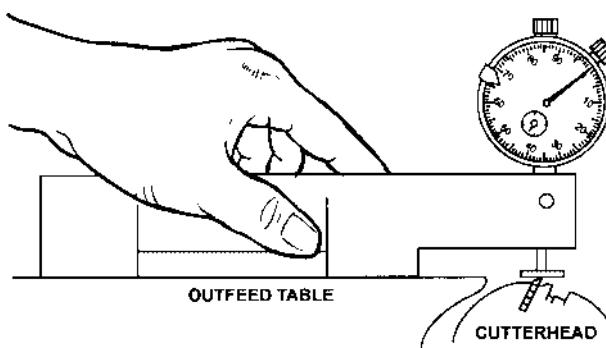


FIGURE 19

SHARPENING THE KNIVES

After extended use it will be necessary to sharpen the knives on the cutterhead assembly.

CAUTION: Wear approved eye protection when sharpening knives.

1. Disconnect machine from power source and remove the cutterhead guard (see page 10).

2. Place a shop scale across the infeed and outfeed tables, as shown in Figure 20.
3. Set tables to the exact height of the high knife at the high point of its arc.
4. Clamp a block of wood across the infeed table so that the end of a sharpening stone may be placed against the wood block during the jointing operation. This will help to prevent kickback of the stone. See Figure 21. Lower the outfeed table .003 inches.
5. Re-connect power and turn machine on.

⚠ CAUTION: Keep hands clear of turning cutterhead.

6. Place a hard 10" Arkansas oilstone over cutterhead with ends resting on infeed and outfeed tables. Slide the oil stone back and forth across the tables until knives are jointed lightly. Turn the machine off and visually inspect each knife. If only the high knife has been touched, lower the outfeed table and continue the sharpening process until every knife has been touched by the stone.
7. After sharpening knives, place a shop scale on the outfeed table. Raise the outfeed table to the original setting parallel with the knife at the high point of the arc.

Weekly sharpening will keep knives in the proper cutting condition. If knives are excessively worn or nicked, they must be reground to a new bevel. If this is the case, follow the above procedure.

CUTTERHEAD REMOVAL

To remove the cutterhead, proceed as follows: (see Figure 22)

1. Disconnect jointer from power source.
2. Remove fence assembly and drive belt.
3. Remove the nuts and washers from the two bearing housing retaining screws (A) front and rear.
4. Loosen lock knobs (B) and lower infeed and outfeed tables.
5. Loosen the two hex head screws attaching fence support (C) with a 9/16" wrench, and turn support 90 degrees on edge as shown.
6. Lift cutterhead straight up from machine.

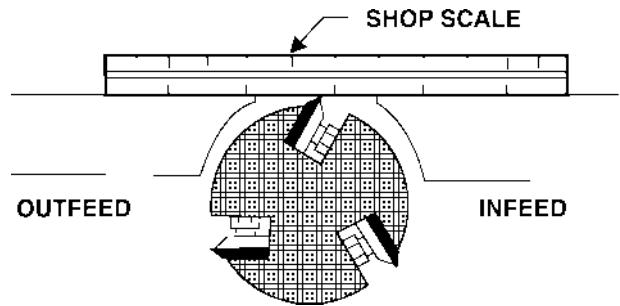


FIGURE 20

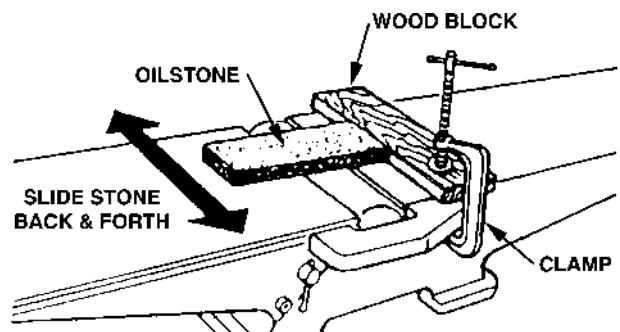


FIGURE 21

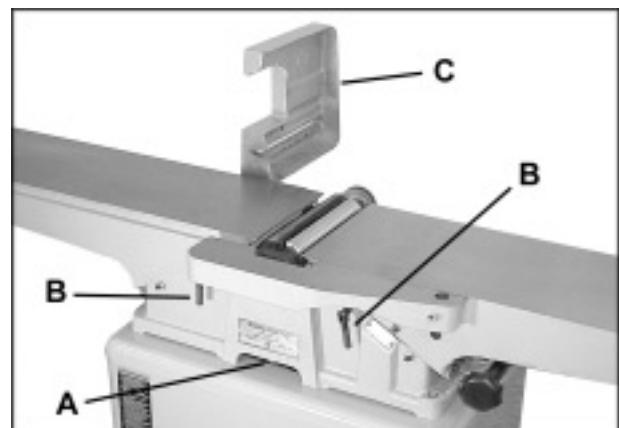


FIGURE 22

NOTE: After re-assembly of cutterhead to jointer, the infeed table will have to be leveled (see "Leveling Tables", page 10)

BEARING REPLACEMENT

1. Disconnect machine from power source.
2. Remove the cutterhead assembly (see "Cutterhead Removal", page 15).
3. Remove bearing housings, Figure 23.
4. Remove bearings with an arbor press or wheel puller.
5. Use fine emery cloth to remove any fine rust. Clean the cutterhead shaft and coat with oil.
6. Press new bearing onto shaft, replace bearing housings, and re-install cutterhead assembly.

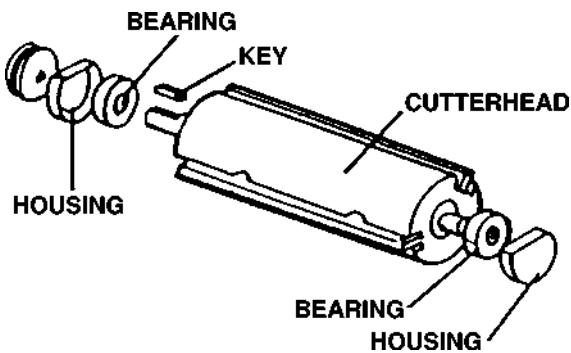


FIGURE 23

TABLE REMOVAL

1. Disconnect machine from power source.
2. Remove the entire fence assembly except for the support bracket.
3. Remove the cutterhead guard (see page 10).
4. Lower the infeed and outfeed tables and remove cutterhead (see pg. 15).
5. Loosen the gib set screws and table lock screws.



CAUTION: After gib screws are loosened, table could suddenly slide down.

6. Remove infeed or outfeed table by sliding upward.

BASIC JOINTER OPERATION

Before making actual cuts on the stock, make some practice runs with the power disconnected and the infeed table raised to "0". This will acquaint the operator with the feel of jointer operations.

This section briefly discusses some of the basic cuts using a jointer: surfacing, edging, beveling, skewing, and rabbeting.

SURFACING (Planing)

The use of push blocks or handle pads will help to ensure against the operator's hands coming into contact with the cutterhead in the event of a kickback and as the trailing end of the board passes over the cutterhead.

Adjust the infeed table for depth of cut. Cuts of approximately 1/16 inch at a time are recommended, as this allows better control over the material being surfaced. More passes can then be made to reach the desired depth.

Never surface pieces shorter than 12" or thinner than 3/8" without the use of a special work holding fixture. Never surface pieces thinner than 3" without the use of a push block. On stock 8" to 12" long, use a single two-handed push block, as in Figure 24.

With narrow stock use the type push block shown in Figure 25.

When surfacing short stock over 4" wide, use two push blocks to guide material over cutterhead. See Figure 26.

On stock longer than 12" use two push blocks. Place a push block near the front of piece and start feeding wood with the right hand until guard has opened and cut is started. With the push block, direct pressure down against the table and back against the fence. See Figure 27. Place second push block near the rear of infeed table and continue feeding stock. Before the left hand is in the 3" area of the cutterhead, move it over to the outfeed side. As soon as possible follow with the right hand over to the outfeed side and continue through with the cut.

NOTE: When the stock is longer than twice the length of the infeed and outfeed tables, an assistant or support table must be used to support the stock.

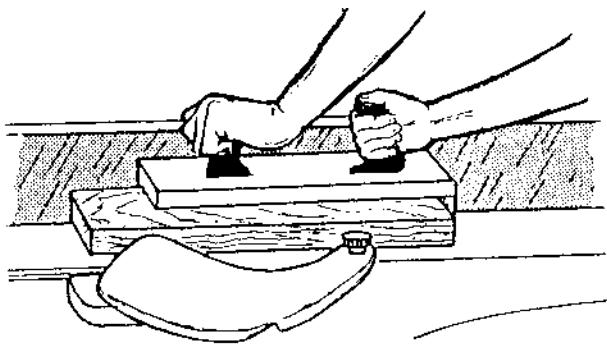


FIGURE 24

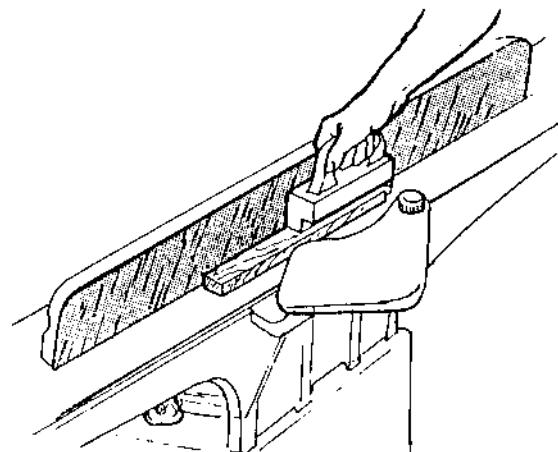


FIGURE 25

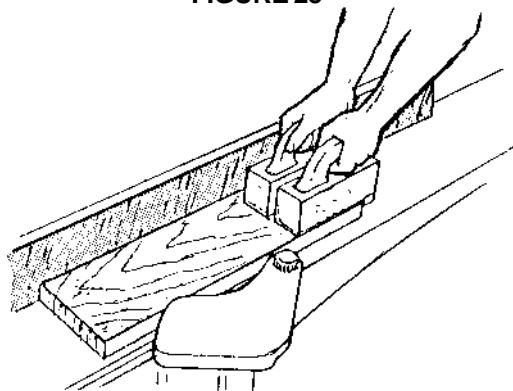


FIGURE 26

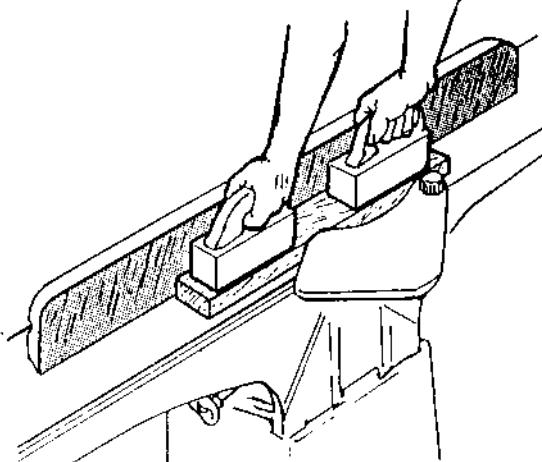


FIGURE 27

EDGING (Jointing)

Never edge a board that is less than 3" wide, less than 1/4" thick, or 12" long without using a push block.

! CAUTION: When workpiece is twice the length of the jointer infeed or outfeed table, use an infeed or outfeed support.

Begin by feeding stock with the right hand and applying pressure to front of stock with push block. When edging, make cuts of approximately 1/16" for hardwood and 1/8" for softwood.

When edging stock wider than 3", lap the fingers over the top of the wood, extending them back over the fence such that they will act as a stop for the hands in the event of a kickback. See Figure 28. Keep stock against the fence.

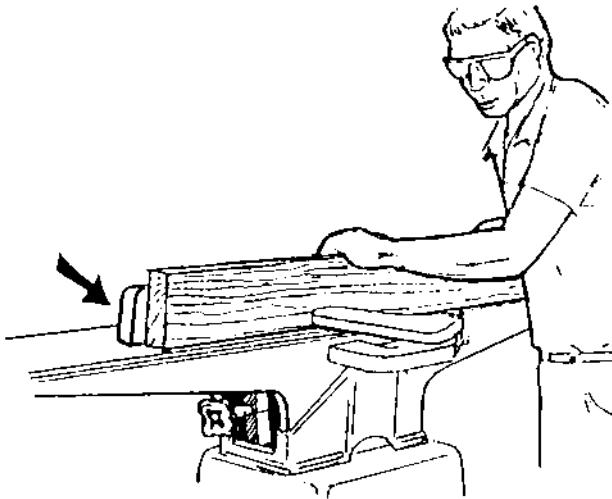


FIGURE 28

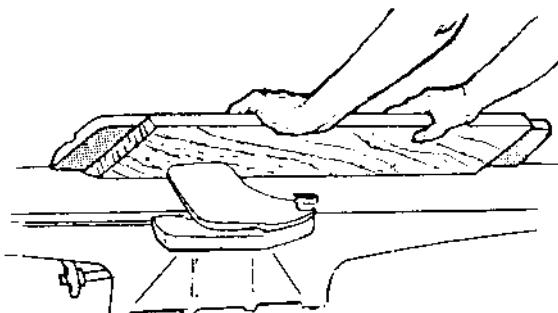


FIGURE 29

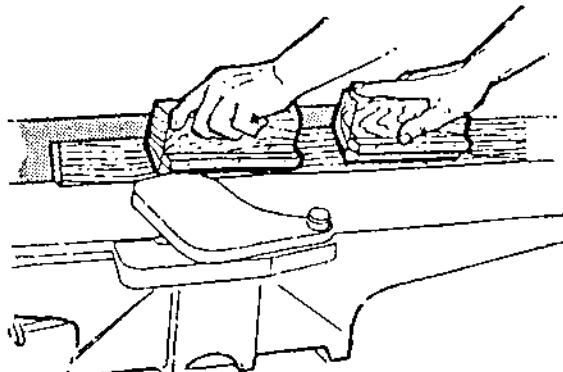


FIGURE 30

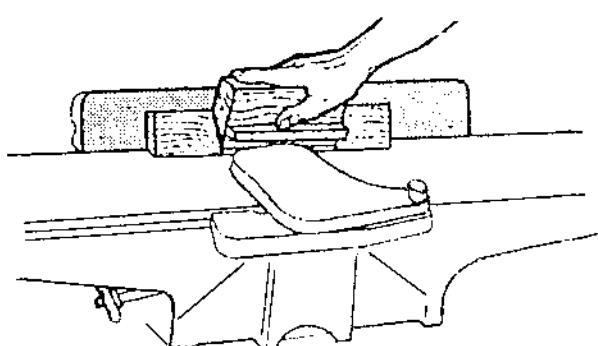


FIGURE 31

SKEWING (Shear cutting)

When edging or facing burl or birds-eye maple, it is not unusual to deface or mar the surface being finished. This is caused by the cutterhead blades at times cutting against the grain. In order to prevent the defacing or marring of this type wood, it is necessary to skew, or angle finish, the material being worked.

1. Release the fence locking handle and remove the two hex nuts and flat washers holding the fence to the fence support. Remove the fence assembly.
2. Remove the key from the fence slide base.
3. Replace the fence assembly at the desired angle across the cutterhead. See Figure 32. Secure the fence to the support with the lock nut, then tighten the fence locking handle.



FIGURE 32

RABBETING



WARNING: A rabbet cut requires removal of the cutterhead guard. Use extreme caution and keep hands clear of the cutterhead. Always replace guard immediately after rabbeting operation is completed.

The width and thickness of the wood to be rabbeted depends on the width and length of the rabbet. However, never rabbet a piece of wood less than 12" long. Use push blocks to rabbet cut whenever possible.

1. Disconnect machine from power source.
2. Set fence for the desired width of the rabbet.
3. Check the width of the rabbet by measuring the distance from the end of a knife in the cutterhead to the fence.
4. Lower infeed table $1/32"$ at a time and make successive cuts until the desired depth of rabbet has been obtained. See Figure 33. NOTE: It is easier and safer to take a series of shallow cuts.

When rabbeting long pieces, follow the same procedure for surfacing long pieces (page 17).



FIGURE 33

PUSH BLOCKS

Push blocks are simple, yet necessary tools to assist the operator, especially when jointing thin or short stock. Two push pads are included with the Powermatic 60A Jointer.

Figure 34 shows three commonly-used types of push block that can be easily made from scrap materials.

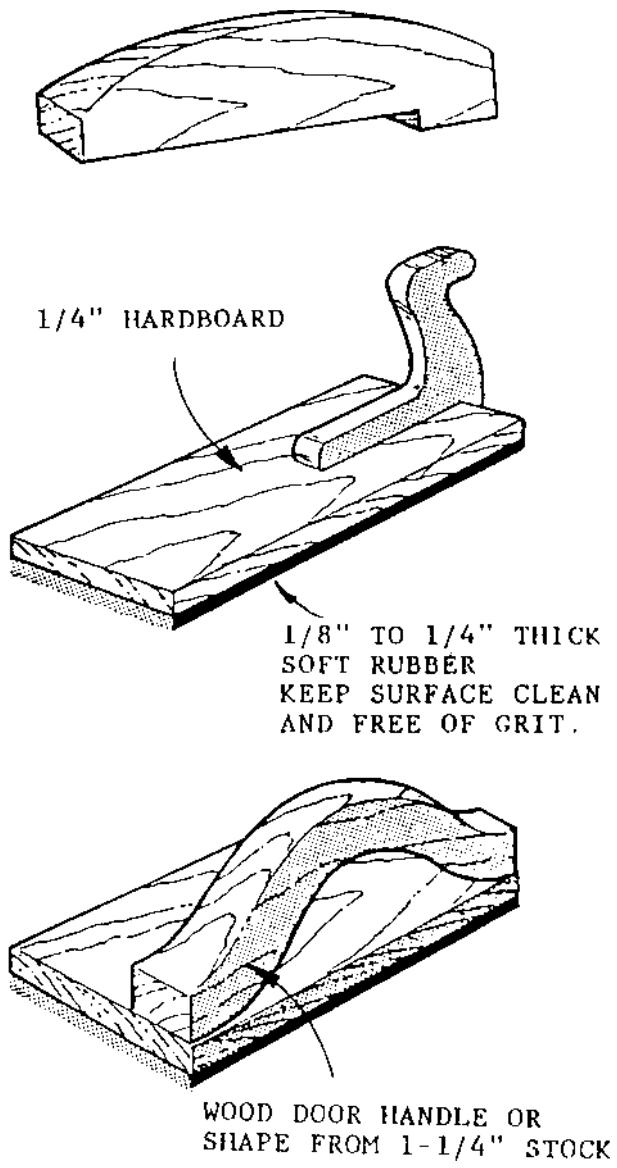
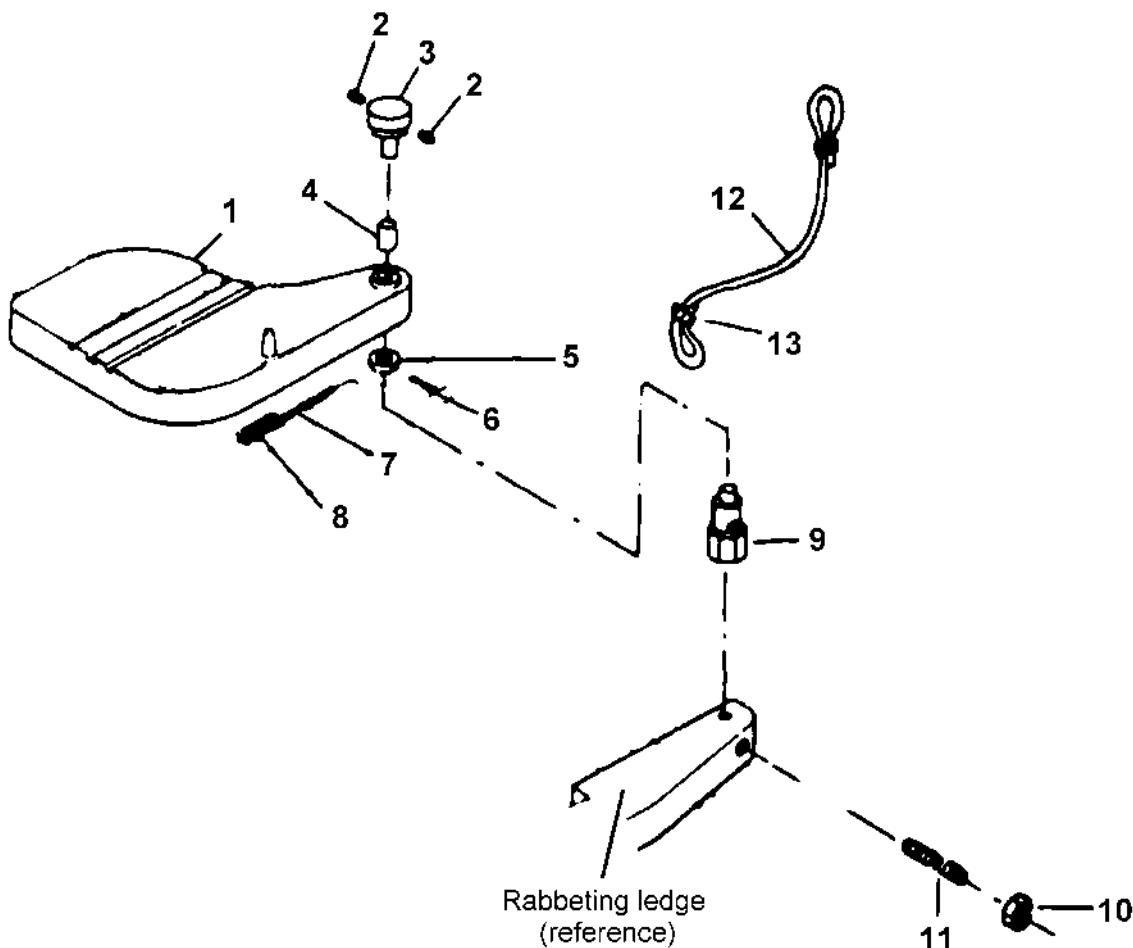


FIGURE 34

PARTS LIST: Cutterhead Guard Assembly (60A Jointer)

No.	Part No.	Description	Quantity
1	3250047	Cutterhead Guard	1
2	6760078	Socket Set Screw, #10-32 x 3/8	2
3	3406017	Knob	1
4	6095024	Bronze Bushing, 5/8 x 3/4 OD x 1-1/4	1
5	3096220	Guard Spring Collar	1
6	6622005	Cotter Key Pin, 1/8 x 1-1/4 x 1/4	1
7	6114013	Sash Chain, 8 x 2-3/8" Lg	1
8	6813022	Extension Spring, J-8-1, 1/2 OD x 3-3/4 Lg	1
9	3711009	Pivot Shaft	1
10	6515007	Hex Jam Nut, 5/16-18	1
11	6715119	Dog Point Socket Set Screw, 5/16-18 x 1 Lg	1
12	6102001	Cable	1
13	6284104	Cable Fitting	1



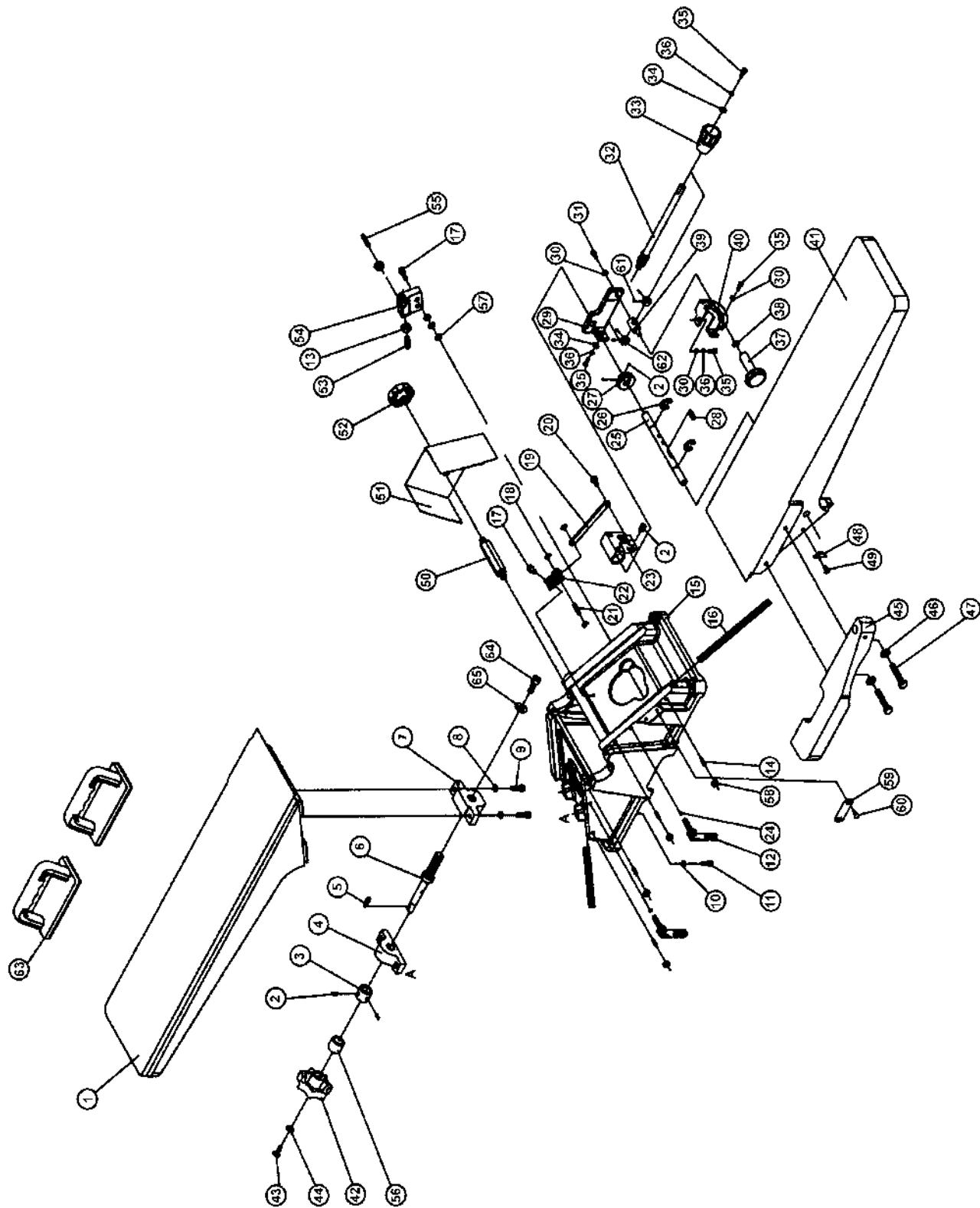
PARTS LIST: Base & Table Assembly (60A Jointer)

No.	Part No.	Description	Quantity
1	2042373	Jointer Table and Cutterhead Assembly	1
1	6296000	Rear Table	1
2	6285865	Set Screw, 1/4-20 x 3/8 lg	6
3	6296001	Collar	1
4	6296002	Bracket	1
5	6296003	Key, 5mm x 5mm x 12mm	1
6	6296004	Lead Screw	1
7	6296005	Bracket	1
8	6285852	Spring Washer, 3/8 x 5/8	2
9	6296007	Cap Screw, 3/8-16 x 1-1/4 lg	2
10	6296162	Spring Washer, 1/2 x 3/4	2
11	6296009	Cap Screw, 1/2-13 x 1-1/2 lg	2
12	6296010	Bolt	2
13	6285966	Hex Nut, 5/16-18	9
14	6296011	Set Screw, 1/4-20 x 1	4
15	6296012	Base	1
16	6296013	Gib	2
17	6296159	Cap Screw, 5/16-18 x 1	2
18	6296015	Retaining Ring, ETW-6	3
19	6296132	Bar	1
20	6296016	Bolt	1
21	6296017	Shaft	1
22	6296018	Lock Bracket	1
23	6296019	Bracket	1
24	6296020	Ball	2
25	6296021	Shaft	1
26	6296022	Retaining Ring, ETW-12	2
27	6296023	Worm	1
28	6296024	Key, 5mm x 5mm x 20mm	1
29	6296025	Adjusting Base	1
30	6296160	Flat Washer, 1/4 x 1-1/2 x 1/32 thk	4
31	6296027	Hex Screw, 1/4-20 x 3/4 lg	1
32	6296029	Worm Shaft	1
33	6296028	Handle	1
34	6296161	Flat Washer, 1/4 x 3/4 x 1/16 thk	2
35	6296031	Cap Screw, 1/4-20 x 1/2 lg	6
36	6296163	Spring Washer, 1/4 x 1/2	4
37	6296033	Clamp Knob	1
38	6296164	Flat Washer, 1/2 x 1-1/8 x 1/8 thk	1
39	6296035	Lock Plate	1
40	6296036	Plate	1
41	6296037	Front Table	1
42	6296038	Handwheel	1
43	6296039	Screw, 5/16-18 x 1/2 lg	1
44	6296165	Flat Washer, 3/8 x 3/4 x 1/16 thk	1
45	6296041	Locking Link	1
46	6296042	Washer, 3/8	2
47	6296043	Hex Screw, 3/8-16 x 1-1/4 lg	2
48	6296044	Pointer	1
49	6296045	Screw, #8-32 x 1/4 lg	1
50	6296056	Bolt	1
51	6296057	Belt Guard	1
52	6296058	Knob	1
53	6296060	Set Screw, 5/16-18 x 3/4 lg	2
54	6296061	Set Block	1
55	6296062	Bolt	1
56	6296063	Collar	1
57	6296166	Flat Washer, 5/16 x 3/4 x 1/8 thk	6

PARTS LIST: Base & Table Assembly (60A Jointer)

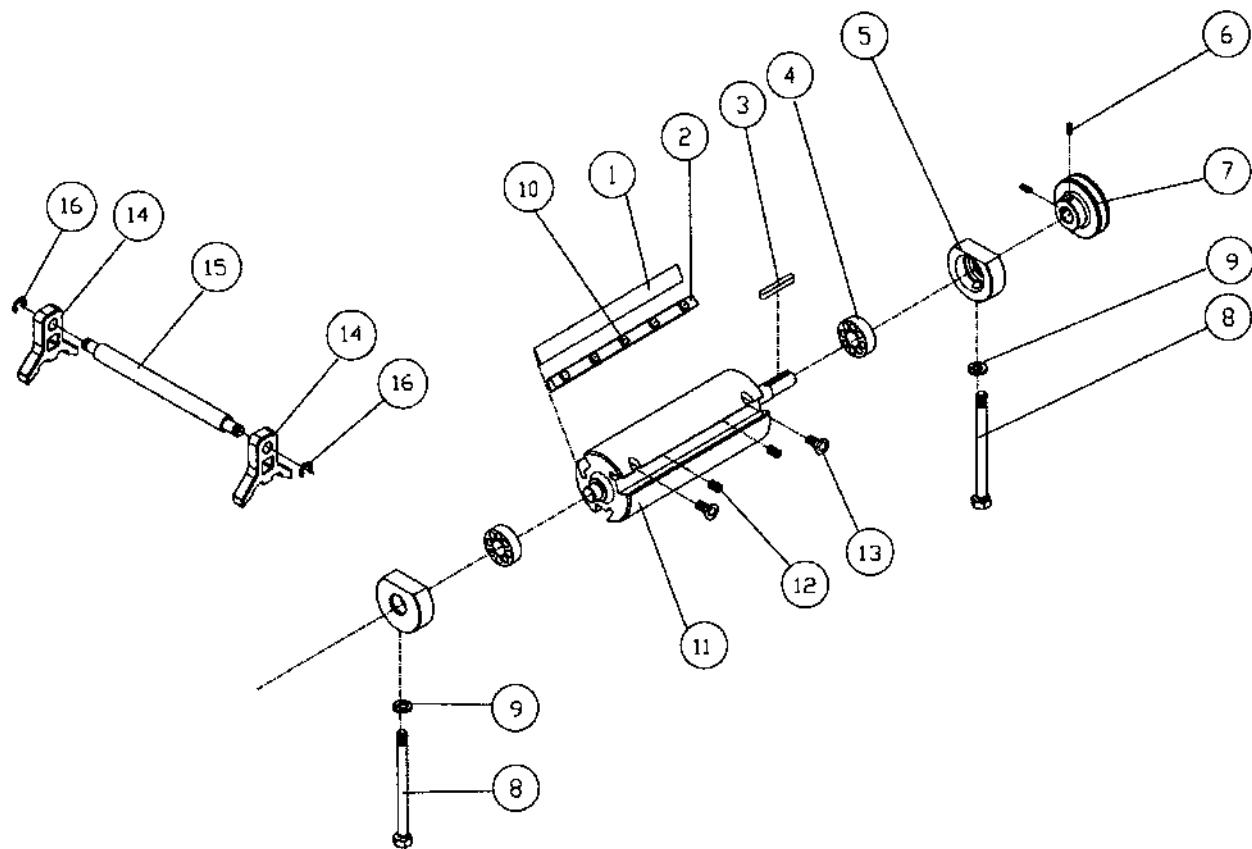
No.	Part No.	Description	Quantity
58	6285830	Nut, 5/16-18 NC	3
59	6296167	Depth Scale	1
60	VS020500	Rivet, 2mm x 5mm.....	2
61	6296152	Set Screw, 1/4-20 x 1/4	4
62	6296151	Collar	2
63	6285917	Push Block	2
64	6296168	Cap Screw, 5/16-18NC x 1/2	1
65	6296166	Washer, 5/16 x 3/4 x 1/8 thk	1

Base & Table Assembly (60A Jointer)



PARTS LIST: Cutterhead Assembly (60A Jointer)

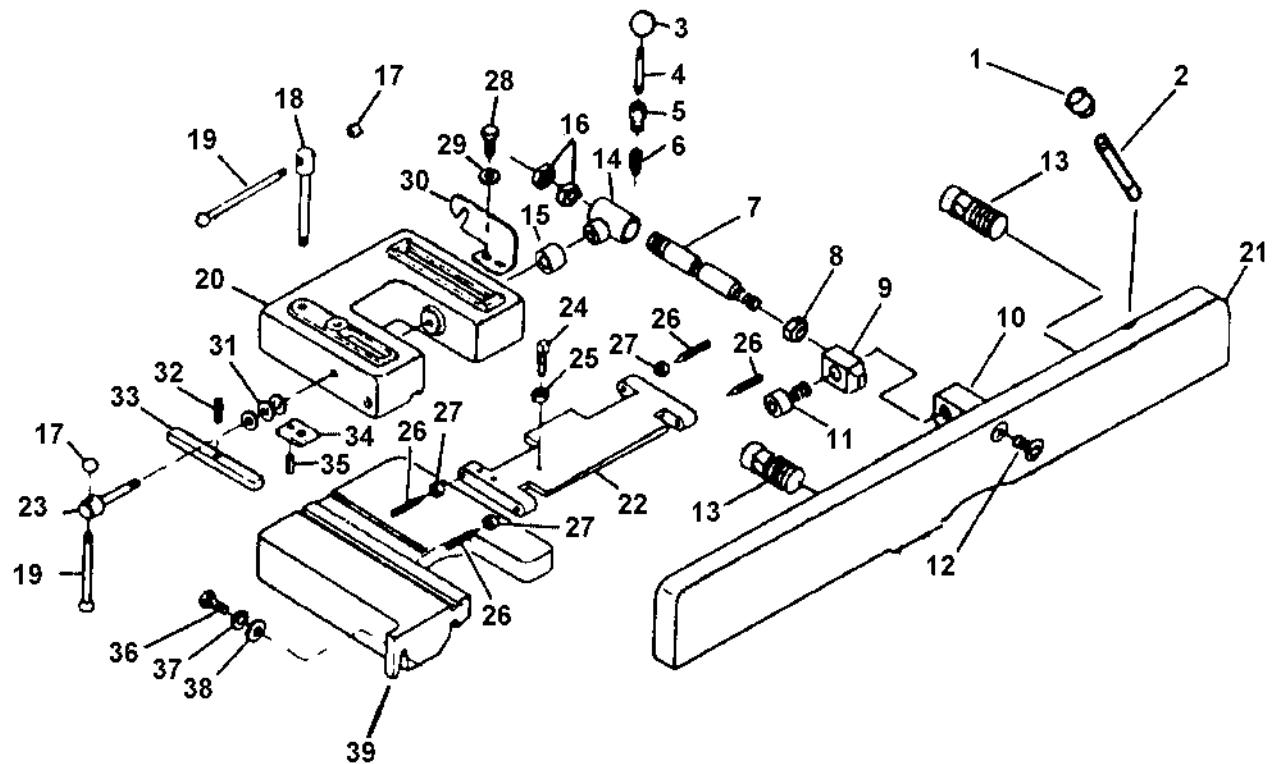
No.	Part No.	Description	Quantity
1	6296046	Knife	3
2	6296153	Knife Bar	3
3	6296048	Key, 5mm x 5mm x 25mm	1
4	6296049	Bearing, #6203-2NSE	2
5	6296050	Bearing Housing	2
6	6296158	Set Screw, 1/4-20 x 1/2 Lg	2
7	6296051	Pulley	1
8	6285853	Bolt	2
9	6285852	Spring Washer, 3/8 x 5/8	2
10	6296154	Square Head Screw	15
11	6296053	Cutterhead	1
12	6296054	Spring	6
13	6296055	Pan Head Screw, M5-08P x 12mm	6
14	6296155	Knife Gauge	2
15	6296156	Knife Gauge Rod	1
16	6296157	E-clip, ETW-6	2



PARTS LIST: Fence Assembly (60A Jointer)

No.	Part No.	Description	Quantity
1	2195007	Fence Assembly (Items 1 thru 39)	1
1	3406201	Teardrop Knob	1
2	3709009	P.F. Control Operator Shaft	1
2	2440005	Plunger Lock Assembly (Items 3 thru 6)	1
3	3406208	Round Nylon Knob, 1/4-20 x 1 Diameter	1
4	3601204	Fence Stop Plunger	1
5	3529012	Fence Stop Operating Nut	1
6	6813002	Spring, J101	1
7	2670015	Rod Assembly (Items 7 thru 9, 14 thru 16, & #2440005 assembly)	1
7	3670109	Degree Tilt Rod	1
8	6567006	Hex Jam Nut, 7/16-20	1
9	3064038	Table Stop Bracket	1
10	3055120	Mounting Block	1
11	6715064	Shoulder Bolt, 3/8 x 3/4	1
12	6715223	Flat Head Socket Cap Screw, 5/16-18 x 1-3/4	1
13	3773314	Pivot Stud	2
14	3092046	Fence Tilting Clamp	1
15	3728003	Fence Tilting Sleeve	1
16	3526205	Thin Hex Nut, 5/8-18	2
17	2695038	Fence Lock Screw Assembly (Items 17 thru 19)	1
17	3406016	Knob	2
18	3695206	Lock Screw	1
19	3268002	Handle	2
20	3042197	Fence Slide Base	1
21	3195121	Table Fence	1
22	3282009	Fence Mounting Hinge	1
23	3695006	Lock Screw	1
24	6715088	Square Head Machine Screw, 5/16-18 x 1	1
25	6515007	Hex Jam Nut, 5/16-18	1
26	6716117	Slotted Head Set Screw, 3/8-16 x 1-1/2	4
27	6516009	Hex Jam Nut, 3/8-16	4
28	6714114	Round Head Machine Screw, 1/4-20 x 3/8 Lg	2
29	6861101	Flat Washer, 1/4	2
30	3064233	Fence Lock Bracket	1
31	6861501	Flat Washer, 1/2	3
32	2386003	Fence Sliding Key Assembly (Items 32 thru 33)	1
32	6626056	Spring Pin, 5/32 x 3/4	1
33	3388031	Key, 3/8 x 10-5/16	1
34	2526001	Fence Sliding Nut Assembly (Items 34 thru 35)	1
34	3528004	Fence Slide Locknut	1
35	6626038	Spring Pin, 1/4 dia. x 1.0 Lg	1
36	6716039	Hex Head Screw, 3/8-16 x 1-1/4	1
37	6861300	Spring Lock Washer, 3/8	1
38	6861301	Flat Washer, 3/8	1
39	3776020	Fence Support	1

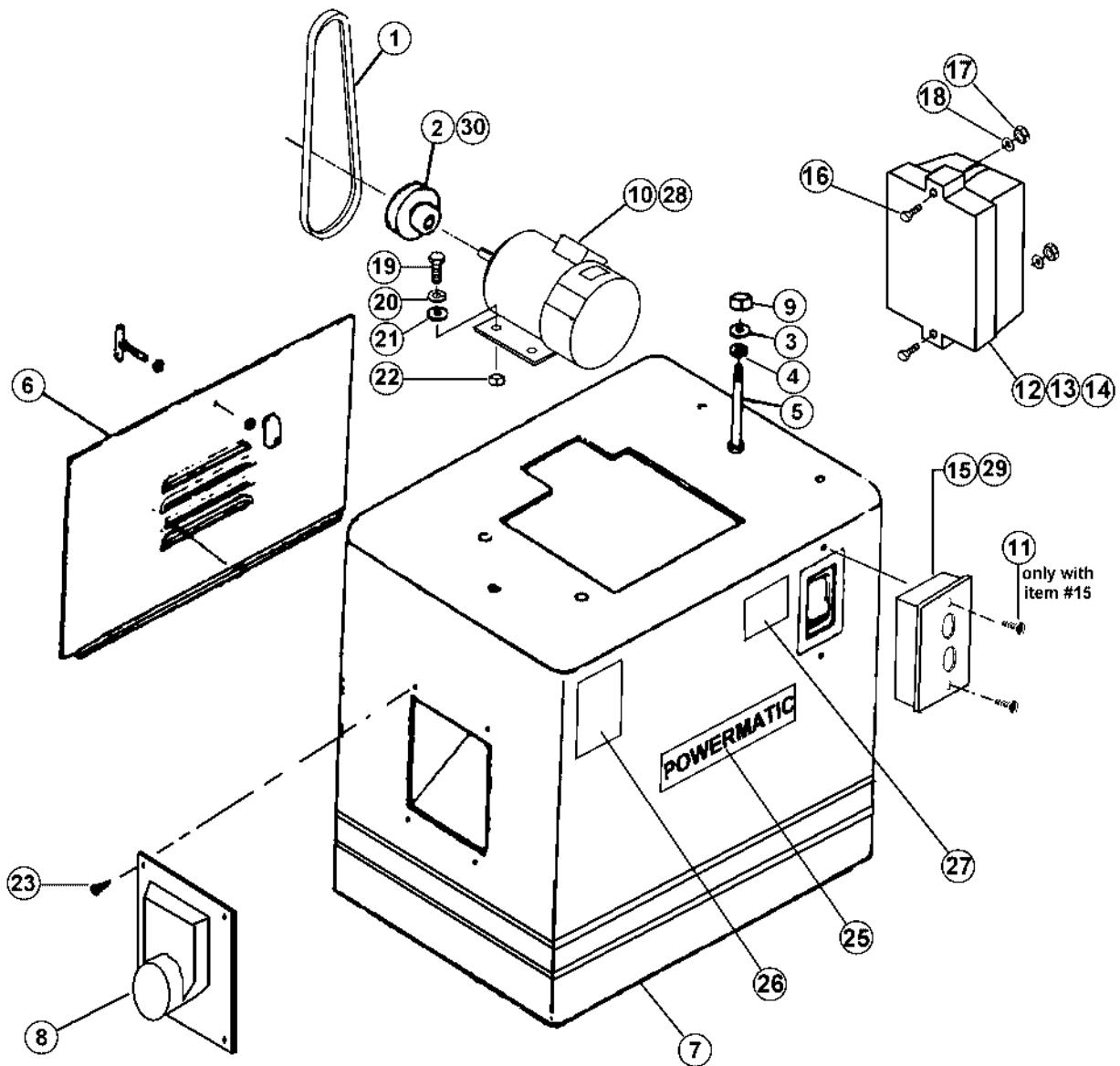
Fence Assembly (60A Jointer)



PARTS LIST: Stand Assembly (60A Jointer)

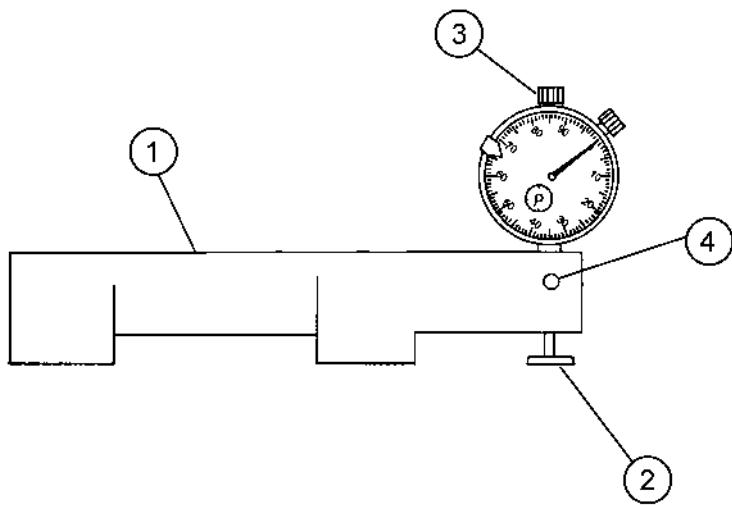
No.	Part No.	Description	Quantity
1	6077234	Belt	1
2	6807135	Motor Sheave, 2 HP	1
3	6861301	Flat Washer	3
4	6861300	Lock Washer	3
5	6716124	Hex Head Screw, 3/8-16 x 2-1/4 Lg	3
6	2136013	Door Assembly	1
7	2759030	Jointer Stand Assembly	1
8	2004017	Dust Collector Adaptor	1
9	6516001	Hex Nut, 3/8-16	3
10	6471706	Motor, 2 HP, 3 Ph, 208/230/460V	1
	6471707	Motor, 2 HP, 1 Ph, 230V	1
11	6756007	Slotted Oval C'Sunk Machine Screw, #6-32 x 3/4 Lg	2
12	6816292	Starter (Single Phase)	1
13	6816295	Starter (Three Phase)	1
14	6816296	Starter (Three Phase)	1
15	6821496	Pushbutton Switch	1
16	6710015	Socket Head Cap Screw, #10-24 x 1/2Lg	2
17	6510001	Hex Nut, #10-24.....	2
18	6860802	Lock Washer, #10	2
19	6715032	Hex Head Cap Screw, 5/16-18 x 1-1/4Lg	4
20	6861200	Lock Washer, 5/16	4
21	6861201	Flat Washer, 5/16	4
22	6515001	Hex Nut, 5/16	4
23	6746023	Hex Washer Head Self Tap Screw, 1/4-20 x 5/8Lg	4
24	6050002	Cloth Bag (contains Items 3, 4, 5 & 9) (not shown)	1
25	3312341	Powermatic Logo	1
26	3408256	Warning Label	1
27	3119080	American Flag Decal	1
28	6471400	Motor, 1-1/2 HP, 1 Ph, 115V	1
29	6821365	Pushbutton Switch	1
30	6807134	Motor Sheave, 1-1/2 HP	1
31	6710153	Self Tap Screw, #10-24 x 1Lg	1
32	6940042	Wire Lug	2
33	6935003	Connector	2

Stand Assembly (60A Jointer)



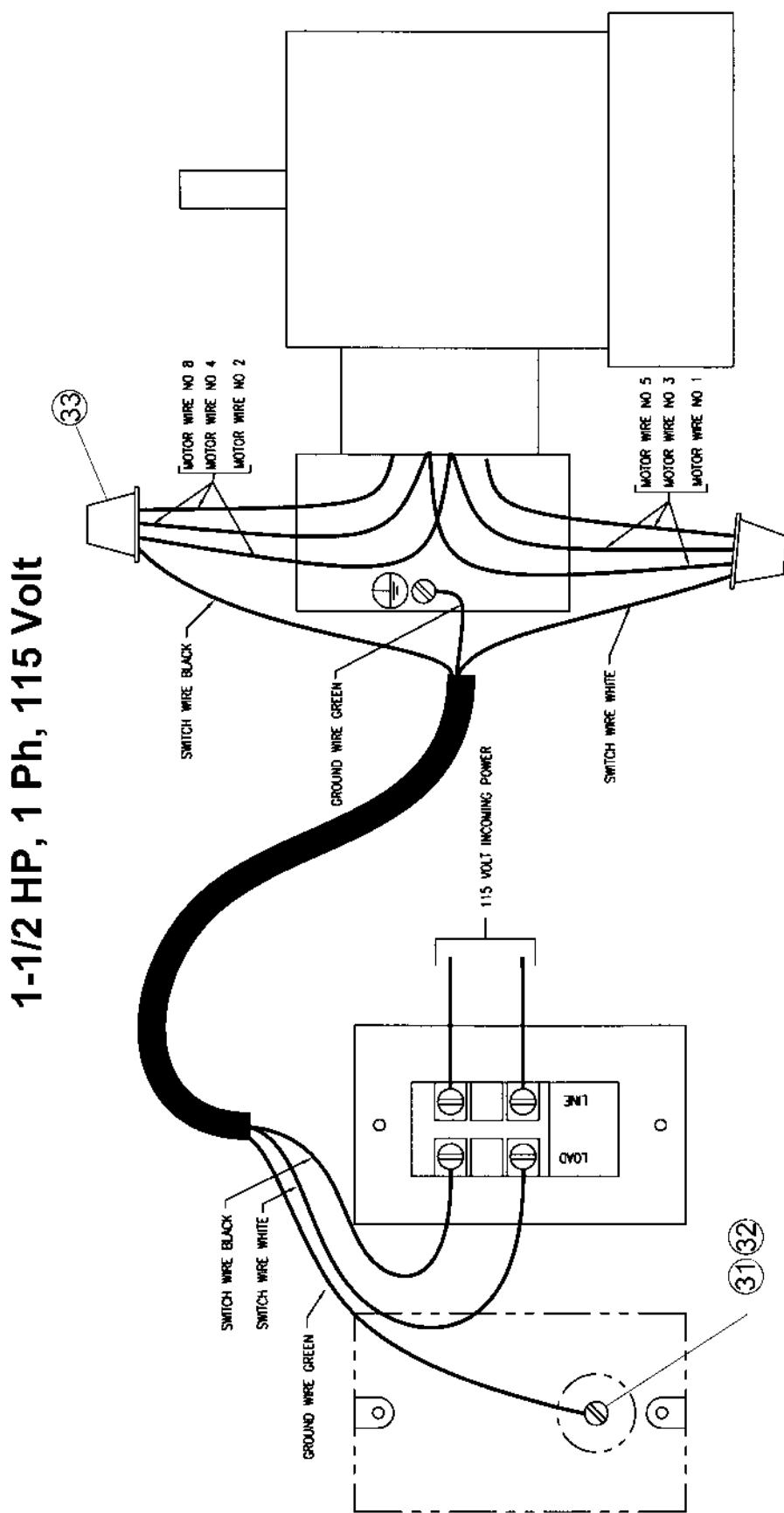
PARTS LIST: Knife-Setting Gauge 2230035 (Optional Accessory)

No.	Part No.	Description	Quantity
1	3042511	Base	1
2	6391008	Pointer	1
3	6391006	Indicator	1
4	6714011	Set Screw	1



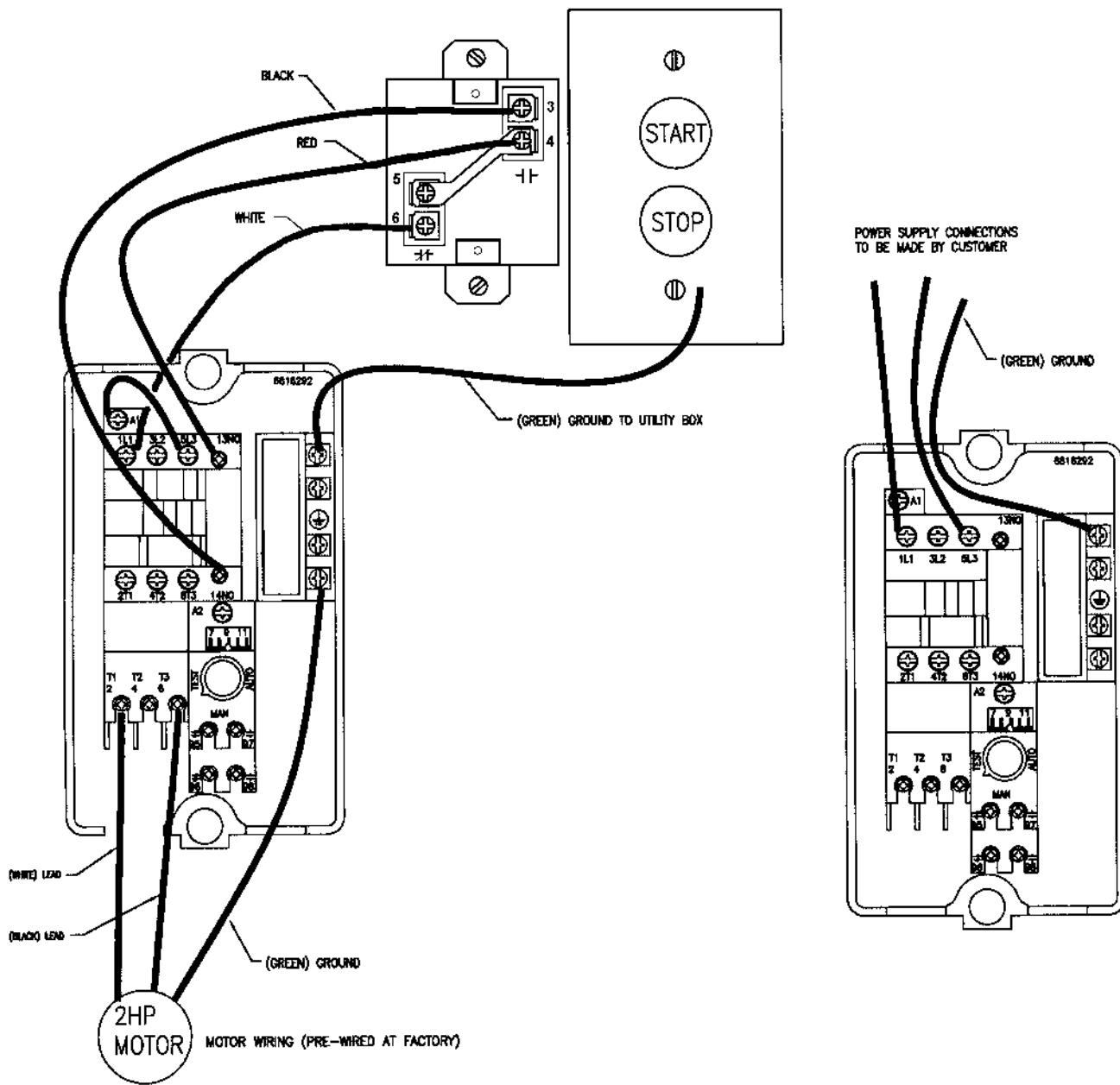
ELECTRICAL (60A Jointer)

Refer to Stand Assembly parts list, page 28.



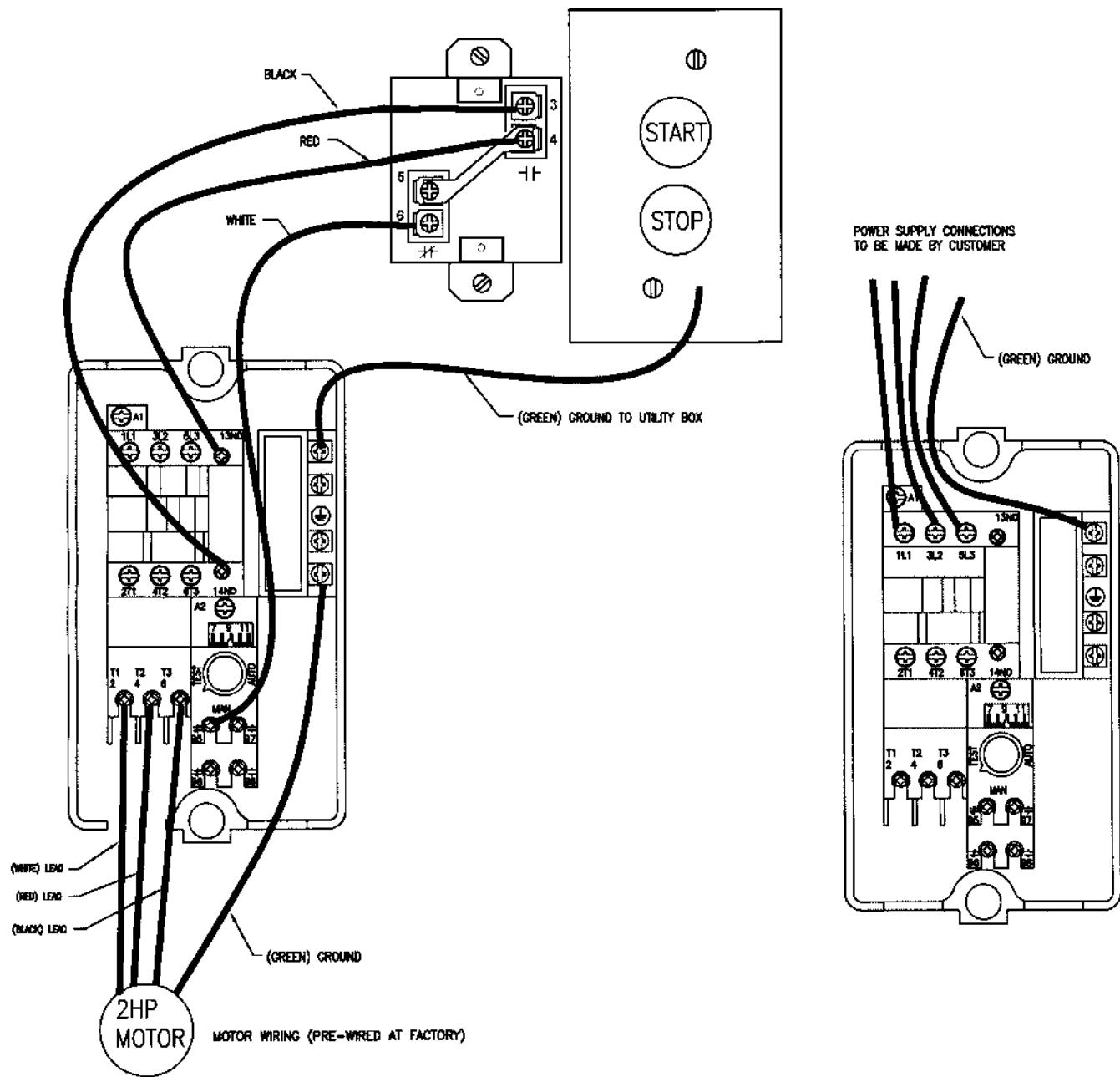
ELECTRICAL (60A Jointer)

FOR NHD ELECTRICALS ONLY
(SINGLE PHASE 230 VOLT)



ELECTRICAL (60A Jointer)

FOR NHD ELECTRICALS ONLY
(THREE PHASE 230/460 VOLT)



ELECTRICAL (60A Jointer)

MAGNETIC STARTERS

Single phase controls

(Stand Assembly 2365016)

	STARTER CONTACTOR
MOTOR 6471707 2 HP - 230V.....	6816292
SWITCH 6821496 Switch (Qty. 1)	

Three phase controls

(Stand Assembly 2365014, 2365015)

	STARTER CONTACTOR
MOTOR 6471706 2 HP - 208/230V.....	6816295
SWITCH 6821496 Switch (Qty. 1)	6816296

OPTIONAL ACCESSORIES

Part No.	Description
2042337	Mobile base.
2230035	Knife-setting gauge.
2397077	"Controlled chip" cutterhead retrofit kit
2759091	Jointer stand only.
6285917	Push block.
6427002	(3) heat-treated M-2 high speed tool steel knives, wt. 1 lb.

PREVENTIVE MAINTENANCE CHECK LIST

Model 60A Jointer

OPERATOR _____ DATE: _____
MODEL NO. _____ S/N _____ ASSET NO. _____

S - Satisfactory A - Acceptable, but needs attention U - Unsatisfactory (red tag)

1. All knives set to be no more than .015 to .025 from cutterhead body.	S A U
2. Knives locked securely in cutterhead.	S U
3. Knives sharp and free of nicks and grooves.	S U
4. Guard in place and working properly.	S U
5. Outfeed table in line with top of arc of cutterhead. All blades arc within .002	S A U
6. All safety decals in place.	S U
7. Working area around machine marked off.	S U
8. Anti-skid strips on floor area where operator normally stands.	S U
9. Various types of push blocks and sticks readily available to operator.	S A U
10. Kickback path not aimed at other work areas, aisles, or doorways.	S U
11. Fence clamps tightly to base and to fence bracket.	S A U
12. No missing parts or loose screws.	S A U
13. Machine is bolted to floor.	S A U
14. Gibs are adjusted to light drag on adjustments for both infeed and outfeed tables.	S A U
15. Locks on infeed and outfeed tables are in position and operate properly.	S A U
16. Table free of pitch, resin, or any foreign material.	S A U
17. Other problems.	S A U

**FORWARD A COPY OF THIS FILLED OUT FORM TO
YOUR SUPERVISOR FOR IMMEDIATE ACTION**

To order parts or reach our service department, please call our toll-free number between 8:00 a.m. and 4:30 p.m. (CST), Monday through Friday. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately. Locating the stock number of the part(s) required from your parts manual will also expedite your order.

Phone No.: (800) 274-6848

Fax No. (800) 274-6840

If you are calling from Canada, please call 800-238-4746

E-mail: powermatic@powermatic.com

Website: www.wmhtoolgroup.com

POWERMATIC

WMH TOOL GROUP

P.O. Box 1349
Auburn, WA 98071-1349
Phone: (800) 274-6848
Fax: (800) 274-6840
E-mail: powermatic@powermatic.com
Website: www.wmhgroup.com